

Date: Tuesday, 8/7/2007 11:52:04 AM  
User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 33836  
Estimate Number : 10346  
P.O. Number :  
This Issue : 8/7/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : 1/1 Type : LANDING GEAR  
Previous Run : 33796  
Written By : JLM 07-08-07  
Checked & Approved By :  
Comment : Est. D 99.02.02 Changed QA to QC, Added Step 6 and Cost D  
M  
Est Rev:E 07-07-09 Incorporated DEO 9183 JLM

Drawing Name : 205 SKIDTUBE "I" BEAM  
Part Number : D2596  
Drawing Number : D2596 REV.D  
Project Number : N/A  
Drawing Revision : D  
Material :  
Due Date : 8/14/2007 Qty: 30 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D25003100 Ext'n - I" Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick;

Qty Part Number Description Batch  
1 D2500-3-100 Extrusion 631223 1313 RJ 507-8-7 (30)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

(30)

50 7-8-10

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

AVM  
07/04/13

4.0 QCS INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/13 (30)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: L-5 07/08/13 AVM

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Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 33836

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.14

Job Completion

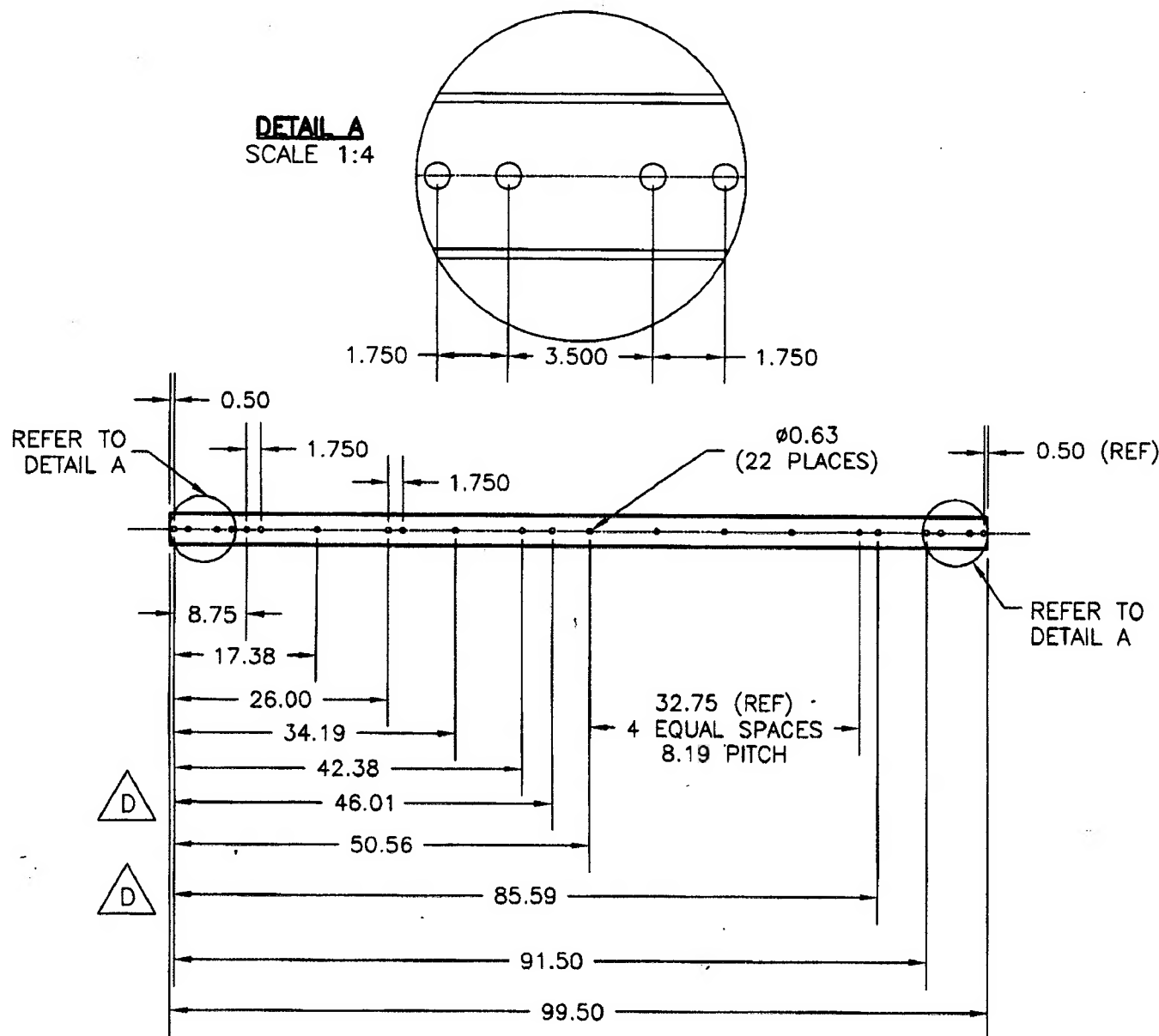


C207/08/14



RELEASED  
07.04.17

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
84	04		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
<i>[Signature]</i>	<i>[Signature]</i>	D2596	
DATE	TITLE	SCALE	
07.04.17	205 WEB	1:20	
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	



**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

